

# Work Order ID 53805

November 18, 2009 12:46:04 PM



Page 1

Item ID: D3564-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 18/11/2009 Start Qty: 20.00

Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Deburr if necessary

UB 9-11-23



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

UB 9-11-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> Sorlu/23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53805

November 18, 2009 12:46:04 PM



Page 2

Item ID: D3564-5

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Setup Start



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Stop



Item Name: Wearshoe

Start Date: 18/11/2009 Start Qty: 20.00

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

09/11/26

22 8

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

2) 09/12/07

contep  
422

150

0.00



Grey Sandtex(Ref:4.3.5.6) per OSI005.4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:30 ☐ OVEN TEMPERATURE: 300 ☐ FINISH TIME: 10:00

09-12-2

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53805**

November 18, 2009 12:46:04 PM



Page 3

Item ID: D3564-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 18/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		MD 09/12/02		X22			
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP19</u>  Memo	0.00  0.00		MD 09/12/02		X22			
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							09/12/03 MF 09-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

November 18, 2009 12:46:09 PM

Work Order ID: 53805



Parent Item: D3564-5RevD



Parent Item Name: Wearshoe

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

190.6742

31.5789

32.



B911-03

304/316 Sheet .063

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

190.6741737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

119.3

22

112885

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53805
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3564-5
<b>Inspection Dwg:</b> D3564	<b>Rev:</b> D	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
2.50	+/-0.030	2.50	✓			
3.227	+/-0.010	3.225	✓			
38.500	+/-0.010	38.500	✓			
5.500	+/-0.010	5.500	✓			
2.50	+/-0.030	2.50	✓			
2.432	+/-0.010	2.439	✓			
0.300 x 0.300	+/-0.010	.300 x .303	✓			
Ø0.188	+0.005/-0.001	.188	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.058	✓			

<b>Measured by:</b>	HB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	9-11-23	<b>Date:</b>	09/11/23	<b>Date:</b>	N/A

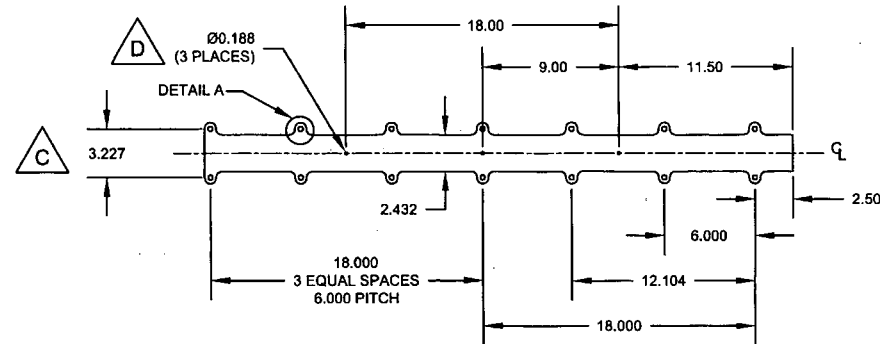
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

SHQ2 COPY

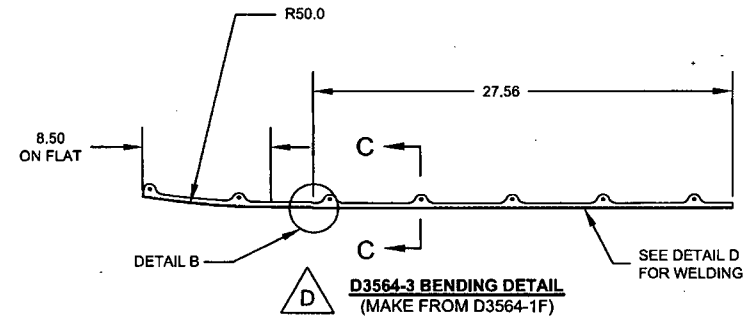
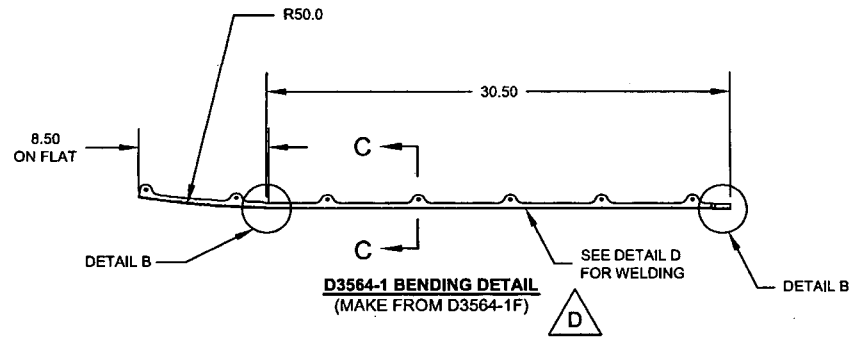
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53805  
09-11-18

RELEASED

07.09.04



D3564-1F FLAT PATTERN



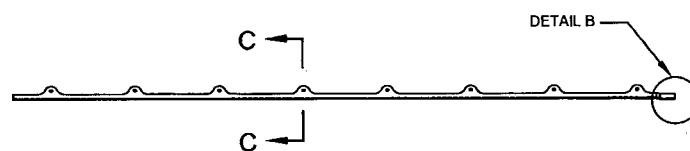
**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

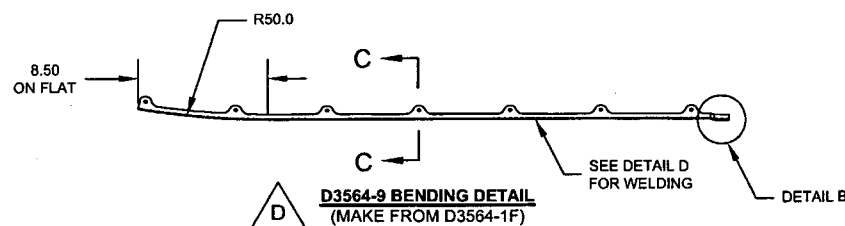
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B6, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3564</b> REV. <b>D</b> SHEET 1 OF 3 TITLE <b>WEARSHOE</b> SCALE <b>1:8</b> <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

### D3564-5F FLAT PATTERN

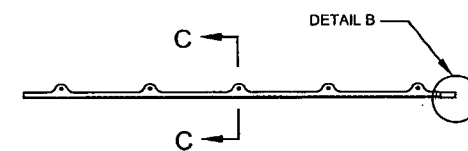


**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

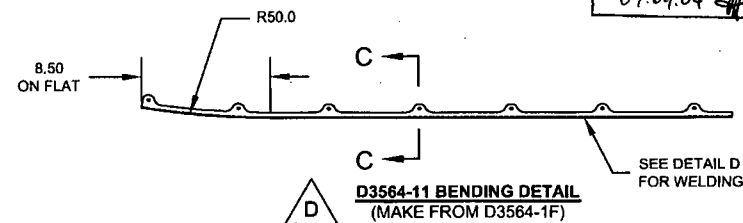


**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)

Technical drawing of a cross-section of a concrete slab with reinforcement details. The drawing shows a slab with a total width of 28.50. On the left, a detail 'C' shows a vertical reinforcement bar with a diameter of 0.188 (2 places) and a height of 3.227. On the right, a detail 'D' shows a horizontal reinforcement bar with a diameter of 0.188 (2 places) and a height of 2.432. The slab has a total thickness of 2.50. The reinforcement is spaced at 5.875 pitch, with 4 equal spaces. The drawing also shows a 10.00 dimension for the top reinforcement and a 9.25 dimension for the bottom reinforcement.



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



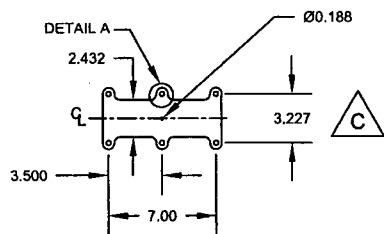
**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED

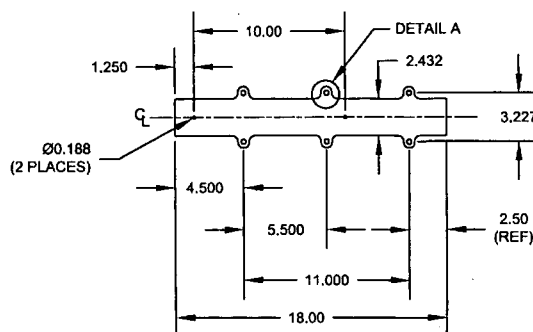
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	21	D3564	SHEET 2 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	SH	WEARSHOE	1:1
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

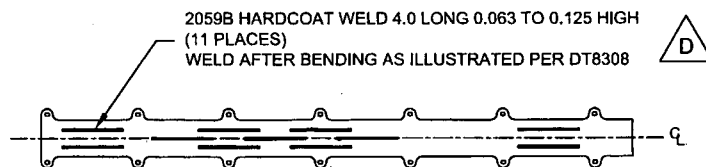
8 7 6 5 4 3 2 1



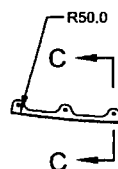
**D3564-13F FLAT PATTERN**



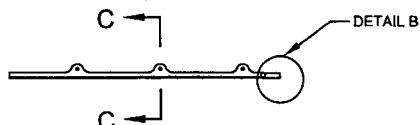
**D3564-15F FLAT PATTERN**



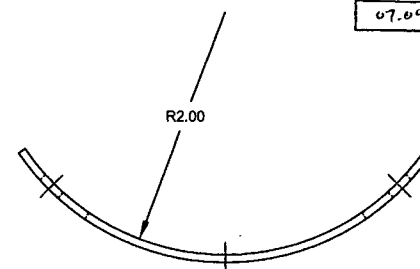
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



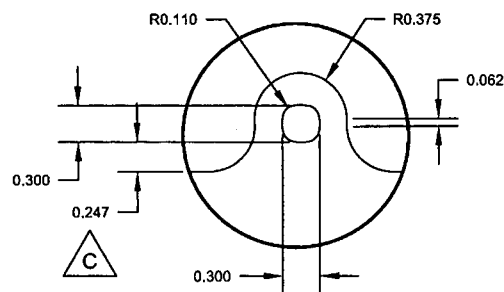
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



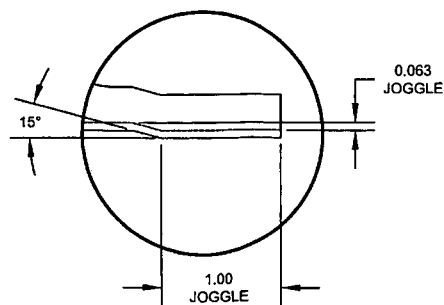
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

**RELEASED**

07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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W/O 53805

8 7 6 5 4 3 2 1